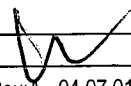


Date: Tuesday, 11/03/2008 2:34:40 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTCOR AFT RH
Job Number : 37827	
Estimate Number : 11235	
P.O. Number :	Part Number : D32814
This Issue : 11/03/2008 S.O. No. :	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : C
Previous Run : 37254	Material :
Written By : 	Due Date : 12/03/2008 Qty: 5 Um: Each
Checked & Approved By :	
Comment : Est Rev A 04.07.01 New issue KJ/JLM	
Est Rev B 07.08.07 Thermoform in house DL	
Ext. Rev C 08.02.06 to reflect updated Dwg. DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	F6006 701	lexan black
-----	-----------	-------------



PTO →

Comment: Qty.: 4.0000 sf(s)/Unit Total : 20.0000 sf(s)
 lexan black

M 106751

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

BB X5

08/03/11

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 010

Dwg. Rev. CFolio Rev. B

BB X5

08/03/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

BB

08/03/11

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Wf. 08.03.11

(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.03.11	1	Material Change to MLEXS 093 F600602: from MLEXS 135 F6006 701	DE	08.03.11	5	UE 08.03.12	08.03.12

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 10 Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/03/2008 2:34:40 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 37827

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(5)

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BL 08.03.11

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.03.12 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 200

AS 08/03/12 (XS)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)

2008/03/12

Job Completion



h 08.03.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

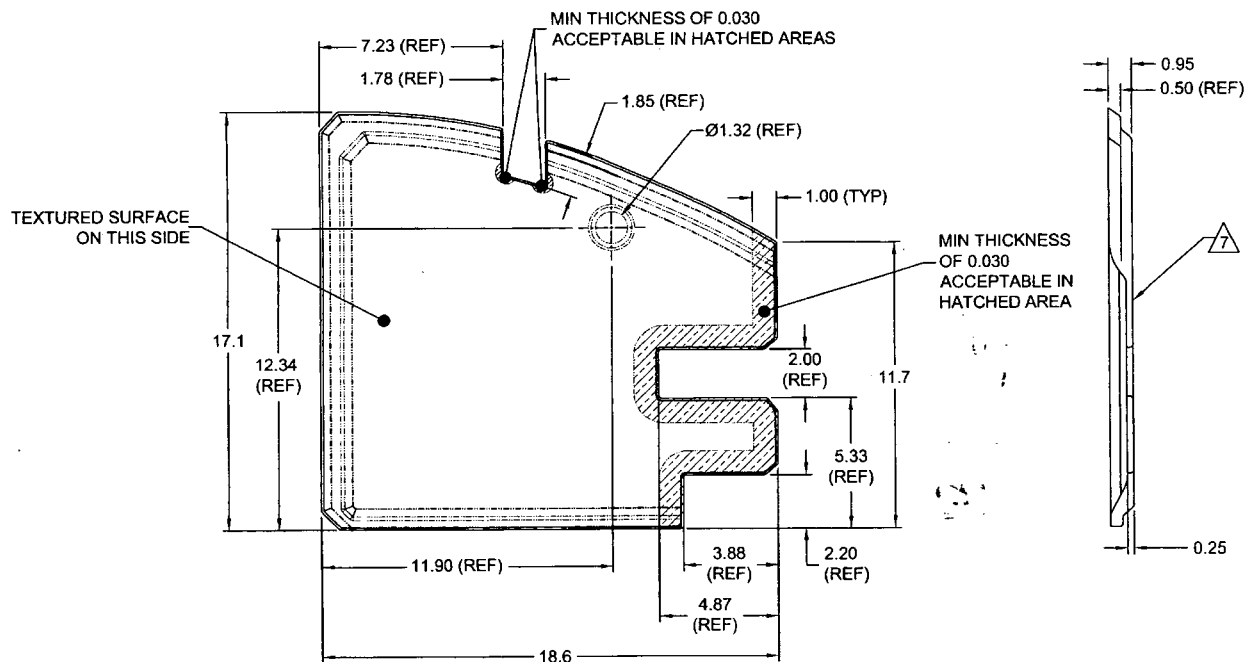
NOTE: Date & initial all entries

RELEASED
07-11-06

D3281-1 FLOOR PROTECTOR

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb



C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	GP		
DRAWN	LE		
CHECKED	MA		
MFG. APPR.	GP		
APPROVED	GP		
DE APPR.	GP		
DATE	07.10.09		

DART AEROSPACE LTD		REV. C
HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 3
DRAWING NO.	D3281	SCALE
TITLE	FLOOR PROTECTOR	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

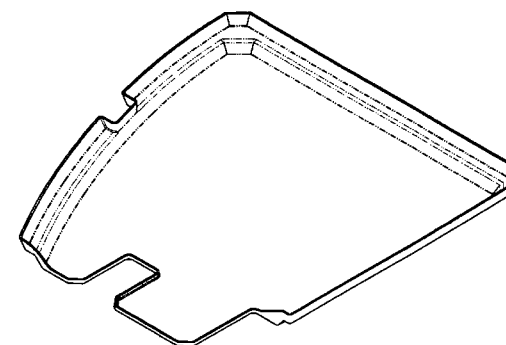
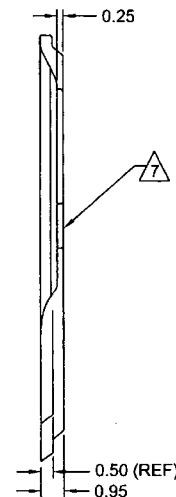
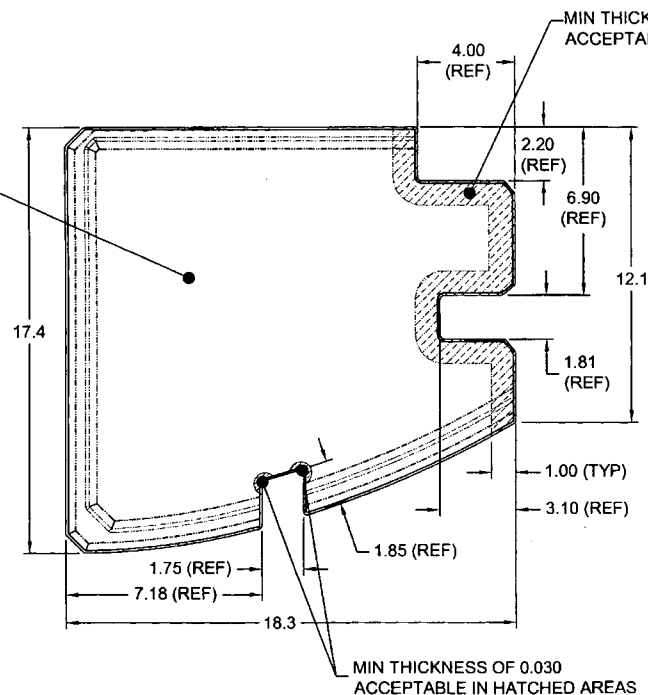
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TEXTURED SURFACE
ON THIS SIDE



RELEASED
07-11-06

D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS. 125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. C
MFG. APPR.	BC	D3281	SHEET 2 OF 3
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	FLOOR PROTECTOR	NTS
DATE	07.10.09	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

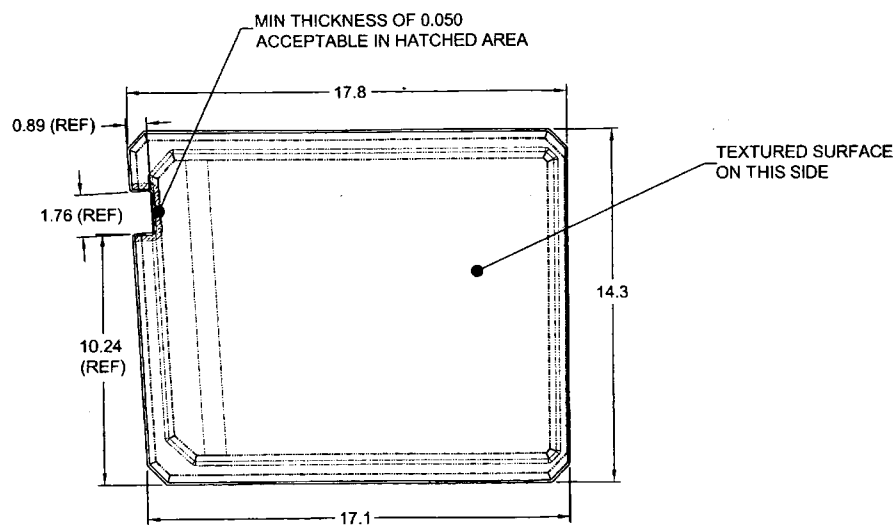
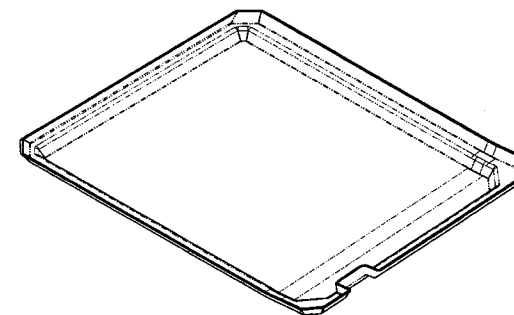
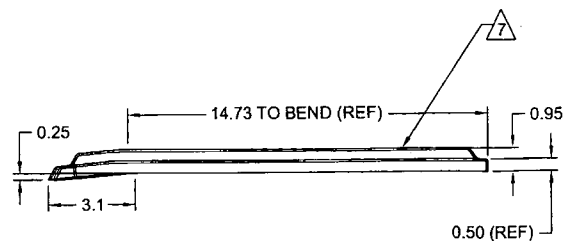
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07-11-06

**D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)**

D3281-3/4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS. 184 F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	DRAWING NO. D3281	REV. C
MFG. APPR.	WJ	SHEET 3 OF 3	
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	FLOOR PROTECTOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 32827
Description: Floor Protector, Aft RH		Part Number: D3281-4
Inspection Dwg: D3281	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL **Date:** 08.03.11

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.8	✓			
17.1	+/-0.100	17.1	✓			
14.3	+/-0.100	14.25	✓			
0.95	+/-0.030	0.966	✓			
0.25	+/-0.030	0.250	✓			
3.1	+/-0.100	3.1	✓			
0.050	Min	0.061	✓			
0.080	+/-0.010	0.075	✓			

Measured by: DL **Date:** 08.03.11

Audited by: DL **Date:** 08/03/11

Prototype Approval: N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	DL